

Work Order ID 156940***156940***

Page 1

Wednesday, February 08, 2017 10:18:13 AM

Item ID: D4038-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Angle, Aft, LH

Start Date: 1/30/2017 Start Qty: 200

2

Cust Item ID:

Required Date: 2/9/2017 Req'd Qty: 200

2

Customer:

Reference:

Approvals:

Process Plan:

DAS

21

Date: FEB 10 2017

Tooling:

Date:

Run Start

NR1

QC:

9-89

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4038

E

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank 7.625" long

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg & Folio FA880

Dwg Rev: AA

Folio Rev: E

Deburr

DAS

33

9-89

17/02/15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

DQA: _____ Date: _____



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Work Order ID 156940***156940***

Page 3

Wednesday, February 08, 2017 10:18:13 AM

Item ID: D4038-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Angle, Aft, LH

Start Date: 1/30/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/9/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

DAS
38
9-89

FEB 27 2017

160

Identify as per dwg & Stock Location: 51573

0.00

160

Packaging

Memo

0.00

Packaging

DAS
6
9-89

FEB 27 2017

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

DAS
21
9-89

FEB 28 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	Pressure/Forced ☐	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	☐ Offset/Setup	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	☐ Supplier	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	☐ Training	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	☐ Use for Testing	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	☐ Poor Information	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	☐ Rushing	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	☐ Product Improvement	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	☐ Process Improvement	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

Picklist Print

Wednesday, February 08, 2017 10:18:13 AM

Page 1

Work Order ID: 156940

156940

Parent Item: D4038-3

D4038-3

Parent Item Name: Angle, Aft, LH

Start Date: 1/30/2017

Required Date: 2/9/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A4.000W.250		Purchased	No			100	f	35.3700	0.7	1.473684			

M6061T6A4 000W 250

6061T6 ANGLE 4.00 x 4.00 x .250

Location

Loc Qty

Loc Code

MAT028

35.37

m118106

25.507

m128265

9.863

3.844 * 17-02-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Misidentified ☐	Past Due ☐																																																																

DART AEROSPACE LTD		Work Order: 156940
Description: Angle, Aft, LH		Part Number: D4038-3
Inspection Dwg: D4038	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

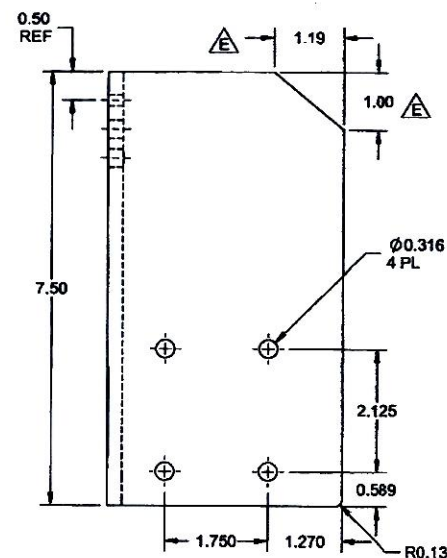
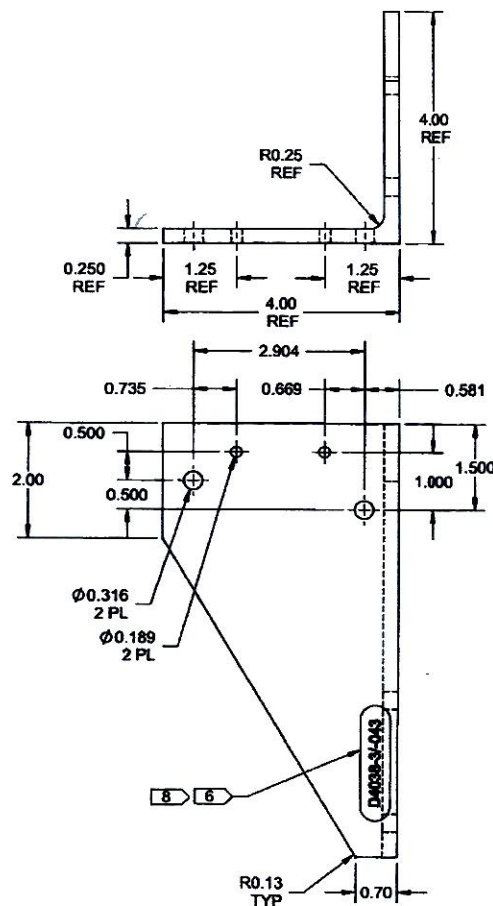
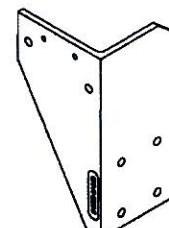
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	+/-0.030	3.997	✓		MJP-04	Verify
1.25	+/-0.030	1.250	✓			
4.00	+/-0.030	3.997	✓			
1.25	+/-0.030	1.250	✓			
0.250	+/-0.010	0.247	✓			
R0.250	+/-0.010	0.250	✓			
2.904	+/-0.010	2.904	✓			
0.581	+/-0.010	0.581	✓			
0.669	+/-0.010	0.669	✓			
0.735	+/-0.010	0.735	✓			
0.500	+/-0.010	0.500	✓			
2.00	+/-0.030	2.000	✓			
0.500	+/-0.010	0.500	✓			
Ø0.316	+0.006/-0.001	0.319	✓			
Ø0.189	+0.005/-0.001	0.192	✓			
R0.13	+/-0.030	0.130	✓			
0.70	+/-0.030	0.700	✓			
1.000	+/-0.010	1.000	✓			
1.500	+/-0.010	1.500	✓			
0.50	+/-0.030	0.500	✓			
7.50	+/-0.030	7.500	✓			
1.750	+/-0.010	1.750	✓			
1.270	+/-0.010	1.270	✓			
R0.13	+/-0.030	0.130	✓			
0.589	+/-0.010	0.588	✓			
2.125	+/-0.010	2.125	✓			
1.00	+/-0.030	1.000	✓			
1.19	+/-0.030	1.190	✓			

Measured by: DAS 33 9-89	Audited by: DAS 49 9-89	Preliminary Approval:
Date: 17/02/15	Date: 17/02/17	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	
B	11.04.05	Dimensions updated per Dwg Rev D	KJ	
C	11.06.21	Dimensions updated per Dwg Rev E	KJ	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 156940 MGS
1702-10



RELEASED
2011-02-21

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250
PER AMS-QQ-A-200/8
REF DART SPEC M6061T6A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (NEAR SIDE ONLY) TO MAX
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.18 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

D4038-3 ANGLE. AFT. LH

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D4038	SHEET 5 OF
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.04.11	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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